

Work Order ID 61080

Page 1

August 5, 2010 11:49:09 AM

Item ID: D4048-5

Accept



Setup Start



Revision ID:

Item Name: Mounting Lug

Stop



Start Date: 8/05/10 Start Qty: 4.00



Cust Item ID:

Required Date: 8/13/10 Req'd Qty: 4.00



Customer:

Reference:

Approvals:

Process Plan: ✓

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr	Revision Nbr
D4048	A

100



Bandsaw

Jeaspa Bandsaw

0.00

*OK 10/08/14**40*

110



HAAS 1

HAAS CNC vertical machine #1

0.00

*OK 10/08/15**40*

Memo

MILL AS PER DWG AND FOLIO FA896
DWG REV: A
FOLIO REV: AA

DEBURR

Work Order ID 61080

Page 2

August 5, 2010 11:49:09 AM

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Accept



Setup Start



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Stop



Start Date: 8/05/10 Start Qty: 4.00



Cust Item ID:

Required Date: 8/13/10 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120



QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

0.00

ark 10/08/15

4 Ø

130



QC

Quality Control

QC8- Inspect parts - second check

0.00

M.A 10/08/16

4 Ø

140



HandFinish

Chemical Conversion Coat per QSI005 4.1

0.00

Memo

0.00

M 10 08 16 (4)

Work Order ID 61080

August 5, 2010 11:49:10 AM



Page 3

Item ID: D4048-5

Accept



Setup Start



Revision ID:

Item Name: Mounting Lug

Stop



Start Date: 8/05/10 Start Qty: 4.00



Cust Item ID:

Required Date: 8/13/10 Req'd Qty: 4.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

**Sequence ID/
Work Center ID****Operation
Description**

150



Powdercoat

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

Set Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInspec.
Stamp

0.00

11115281

0.00

=> M

10/08/17

X4

4

Powder Coating

Memo

Mask 0.257" holes and indicated channel prior to powder coat

POWDER COAT:

Start Time: 9:00AM

Oven Temperature: 320°F

Finish Time: 9:30AM

160



QC

QC3- Inspect Part Finish

0.00

Quality Control

Memo

0.00

170



Packaging

Identify as per dwg & Stock Location: ST 119BB

0.00

Packaging

Memo

0.00

Work Order ID 61080

Page 4

August 5, 2010 11:49:10 AM

Item ID: D4048-5

Accept



Setup

Start



Revision ID:

Item Name: Mounting Lug

Stop



Start Date: 8/05/10 Start Qty: 4.00



Cust Item ID:

Required Date: 8/13/10 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

180



QC

Operation
Description

QC21- Final Inspection - Work Order Release

Set Up/
Run Hours

0.00

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Quality Control

Memo

0.00

10/08/19 JJ

MF
10-8-18

Picklist Print

August 5, 2010 11:49:06 AM

Page 1

Work Order ID: 61080



Parent Item: D4048-5



Parent Item Name: Mounting Lug

Start Date: 8/05/10

Required Date: 8/13/10

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP REV:A NEW ISSUE JLM 10-01-26 VERIFIED BY:EC IPP Rev:B
as per dwg revA DD 10.02.18 verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B1.500X04.00 0		Purchased		No		100	f	11.2643	0.444	1.869474			

6061T6 Bar 1.500 x 4.00



Location	Loc Qty	Loc Code
MAT09	11.2643	
113797	11.2643	

1.8695 on 10/08/14

DART AEROSPACE LTD	Work Order:	60080
Description: Mounting Lug	Part Number:	D4048-5
Inspection Dwg: D4048	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Measured by: <u>Ank</u>	Audited by: <u>H.A.</u>	Preliminary Approval:
Date: <u>10/08/15</u>	Date: <u>10/08/16</u>	Date:

Rev	Date	Change	Revised by	Approved
A	10.06.08	New Issue	KJ	 

8

7

6

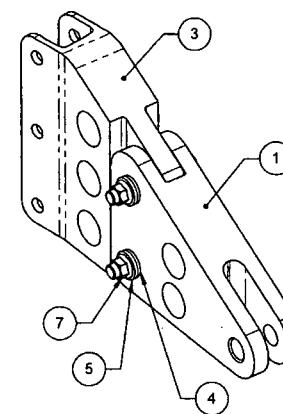
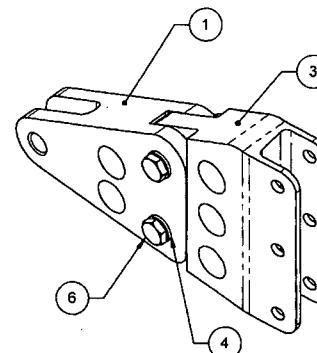
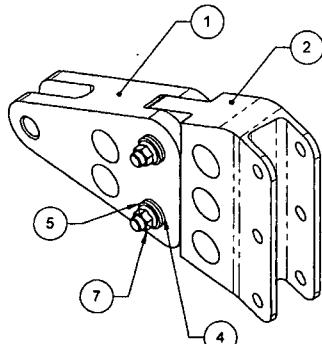
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4

3

2

1



D4048-041 MOUNTING LUG ASSY (SHOWN)

D4048-042 MOUNTING LUG ASSY (SHOWN)

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4048-041/-042" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: D4048-041/-042: 1.16 lbs
- 8) TORQUE AN4 BOLTS TO 50-70 in-lbs (5.6-7.9 Nm)

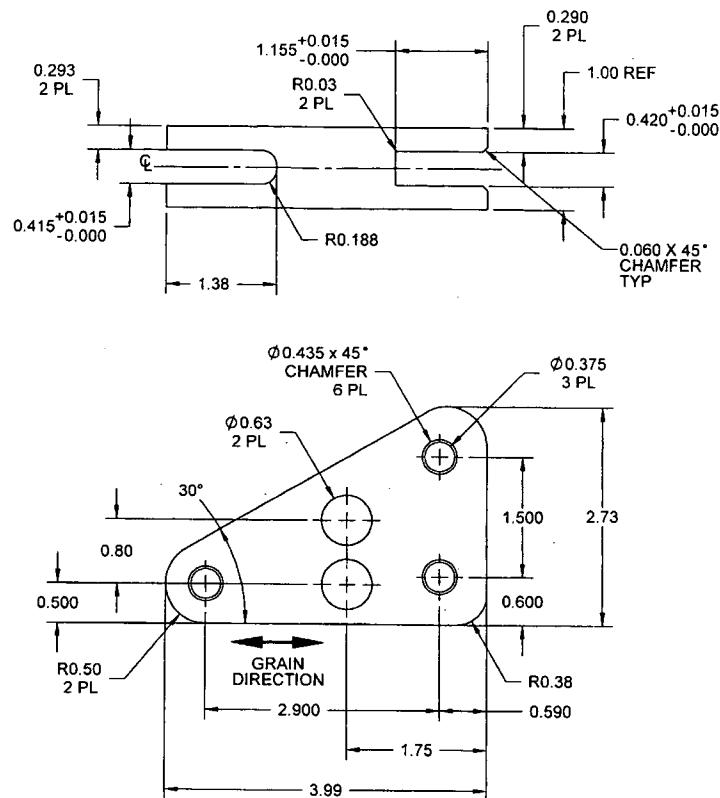
ITEM	QTY -041	QTY -042	P/N	Description
	X		D4048-041	MOUNTING LUG ASSY
		X	D4048-042	MOUNTING LUG ASSY
1	1	1	D4048-1	MOUNTING LUG
2	1	1	D4048-3	MOUNTING LUG
3		1	D4048-4	MOUNTING LUG
4	4	4	D4048-9	BUSHING
5	2	2	AN960JD416	WASHER
6	2	2	AN4-14A	BOLT
7	2	2	MS21042L4	NUT

w/0 b/080

RELEASED
R 2010-02-16

A	NEW ISSUE	RF	10.01.29
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE LTD HAWKSLEY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	99	DRAWING NO.	REV. A
MFG. APPR.	99	D4048	SHEET 1 OF 9
APPROVED	100	TITLE	SCALE
DE APPR.	100	MOUNTING LUG ASSY	NTS
DATE	10.01.29	COPYRIGHT © 2010 BY DART AEROSPACE LTD. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL. IT IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

8 7 1 6 5 4 3 1 2 1



D4048-1 MOUNTING LUG

61080

RELEASED
2010-02-16
MW

NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) BAR
PER AMS-QQ-A-225/8 (OR 4117/4128/4115/4116)
PER AMS-QQ-A-200/8 (OR AMS 4160)
REF DART SPEC. M6061T6B
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3
MASK Ø0.315 HOLES PRIOR TO POWDER COAT
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.47 lbs

DESIGN	RF	DART AEROSPACE LTD
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA
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MFG. APPR.	<i>93</i>	REV. A
APPROVED	<i>93</i>	SHEET 2 OF 9
DE APPR.	<i>93</i>	TITLE
DATE	10.01.29	SCALE
		NTS

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8

7

6

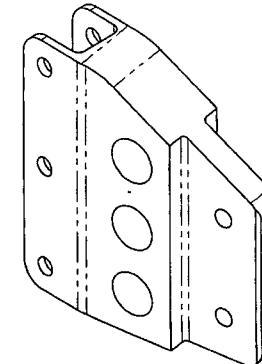
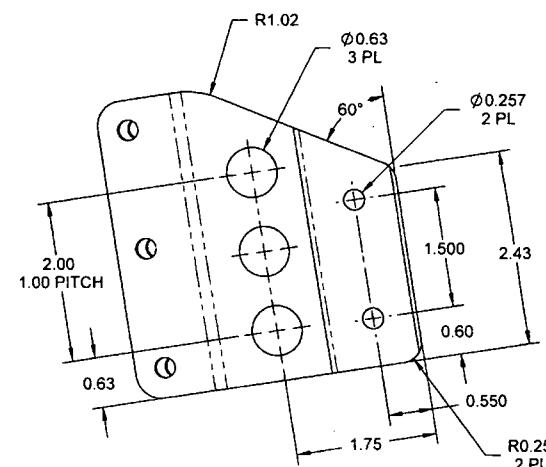
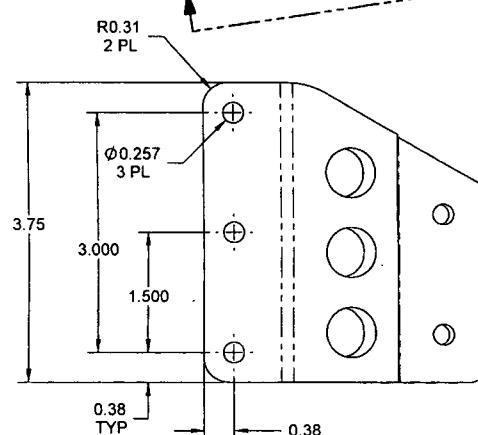
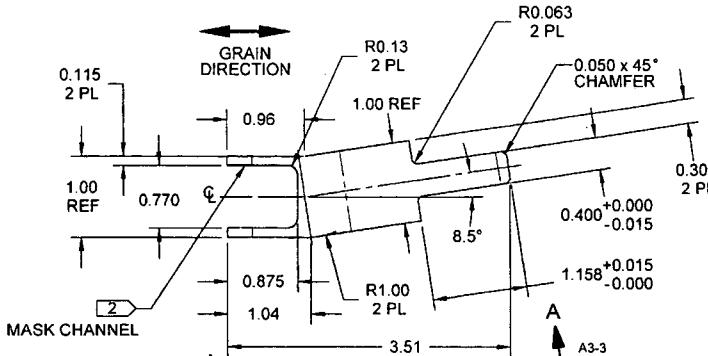
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4

3

2

1



61080

VIEW A-A C5-3

RELEASED
R 2010-02-16
MP

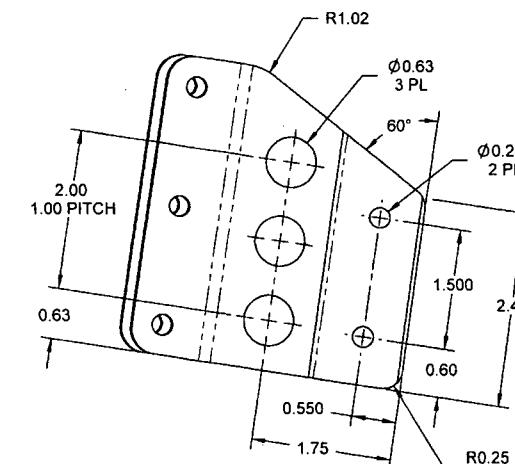
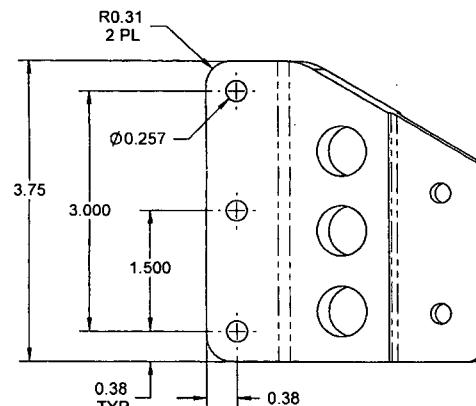
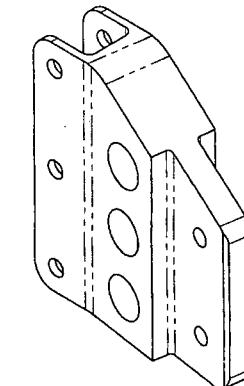
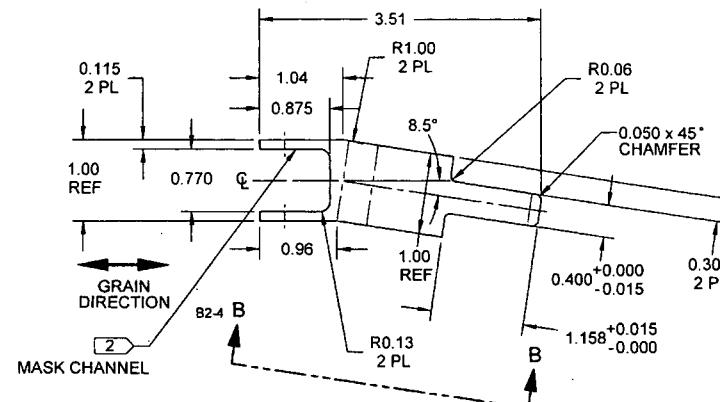
NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) BAR PER AMS-QQ-A-225/8 (OR 4117/4128/4115/4116) PER AMS-QQ-A-200/8 (OR AMS 4160) REF DART SPEC. M6061T6B
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3 MASK Ø0.257 HOLES AND INDICATED CHANNEL (ZN C7-3) PRIOR TO POWDER COAT
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.61 lbs

D4048-3 MOUNTING LUG

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i> <th data-cs="2" data-kind="parent">DRAWING NO.</th> <th data-kind="ghost"></th>	DRAWING NO.	
MFG. APPR.	<i>[Signature]</i>	D4048	REV. A
APPROVED	<i>[Signature]</i>		SHEET 3 OF 9
DE APPR.	<i>[Signature]</i>	TITLE	SCALE
DATE	10.01.29	MOUNTING LUG ASSY	NTS

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NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) BAR PER AMS-QQ-A-225/8 (OR 4117/4128/4115/4116) PER AMS-QQ-A-200/8 (OR AMS 4160) REF DART SPEC. M6061T6B
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3 MASK Ø0.257 HOLES AND INDICATED CHANNEL (ZN C7-4) PRIOR TO POWDER COAT
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.61 lbs

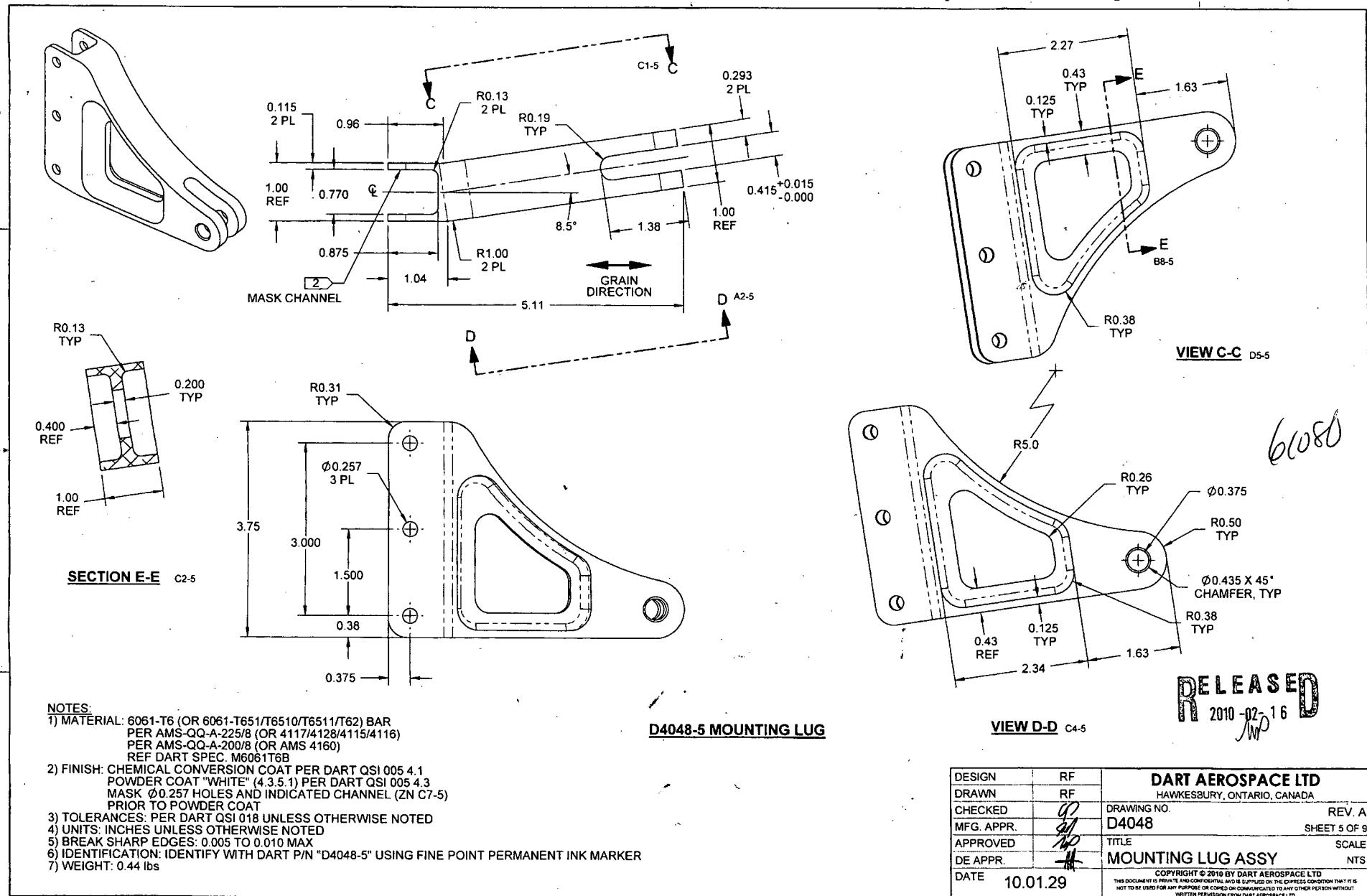
D4048-4 MOUNTING LUG

VIEW B-B C6-4

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2010-02-16
M

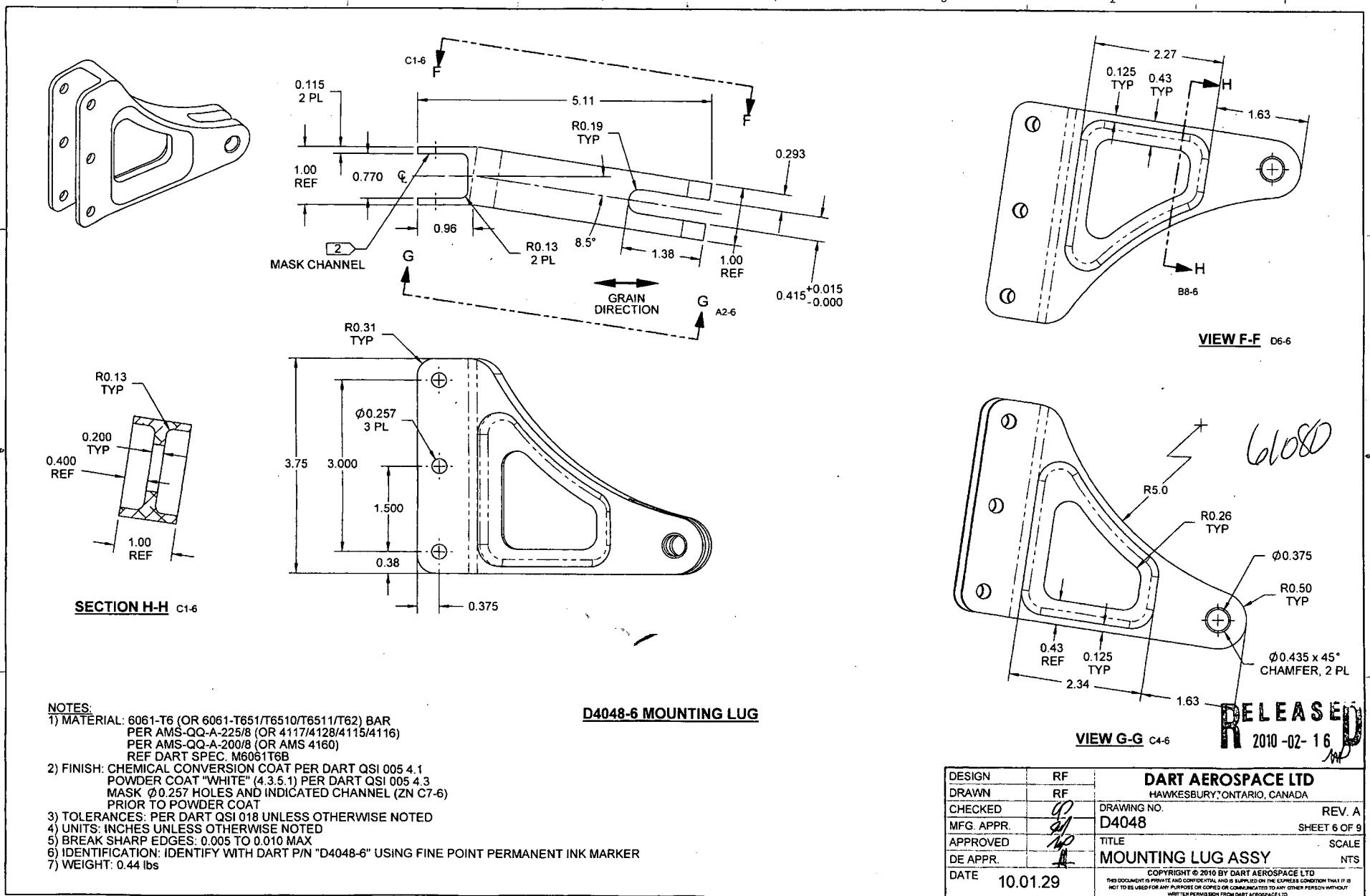
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DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	99	REV. A	
MFG. APPR.	99	DRAWING NO.	
APPROVED	99	D4048	SHEET 4 OF 9
DE APPR.	99	TITLE	SCALE
DATE	10.01.29	Mounting Lug Assy	NTS

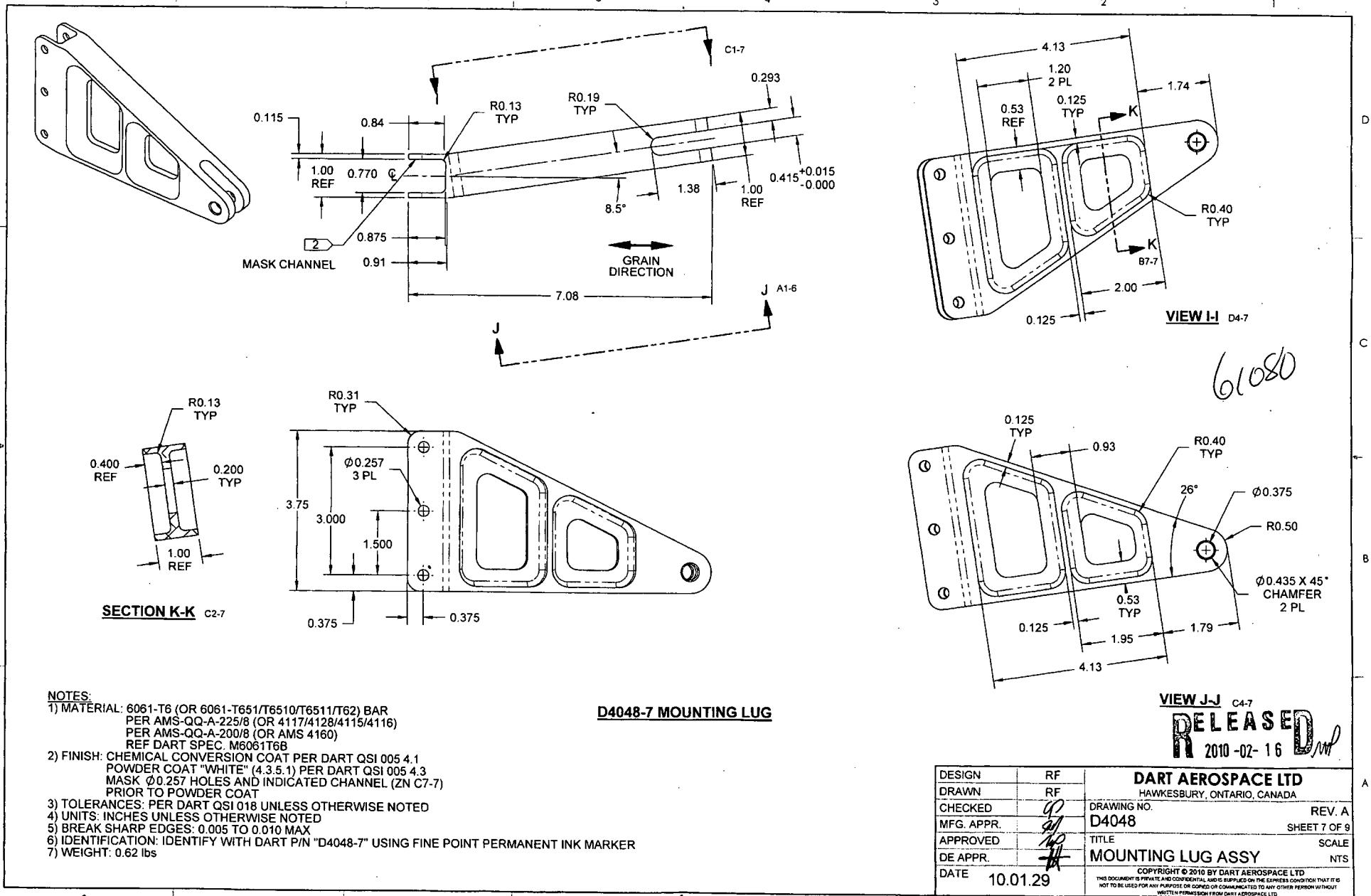
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MFG. APPR.	<i>99</i>	D4048
APPROVED	<i>99</i>	REV. A
DE APPR.	<i>99</i>	SHEET 5 OF 9
DATE	10.01.29	TITLE
		MOUNTING LUG ASSY NTS

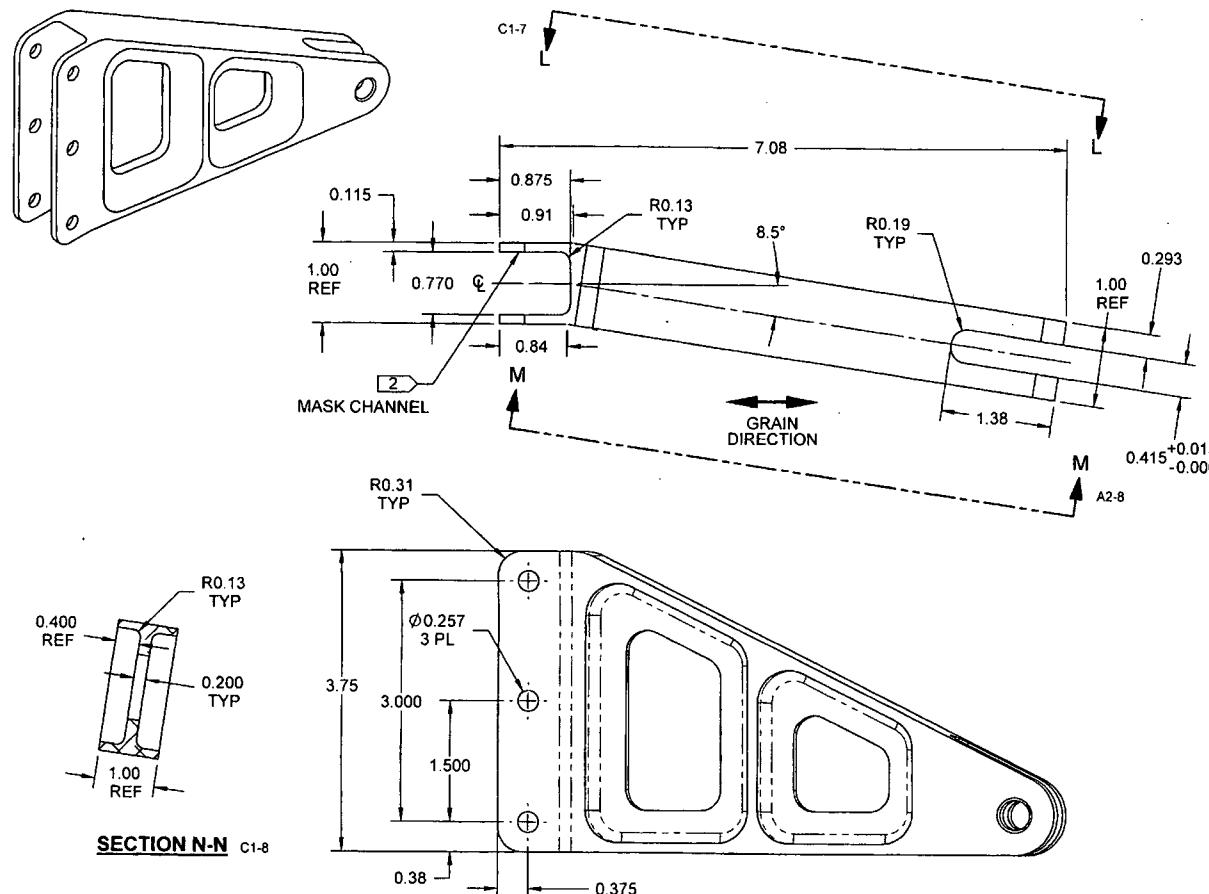
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DRAWN	RF	HAWKSLEY, ONTARIO, CANADA
CHECKED	<i>GP</i>	REV. A
MFG. APPR.	<i>SP</i>	SHEET 7 OF 9
APPROVED	<i>DP</i>	
DE APPR.	<i>SP</i>	
DATE	10.01.29	SCALE NTS

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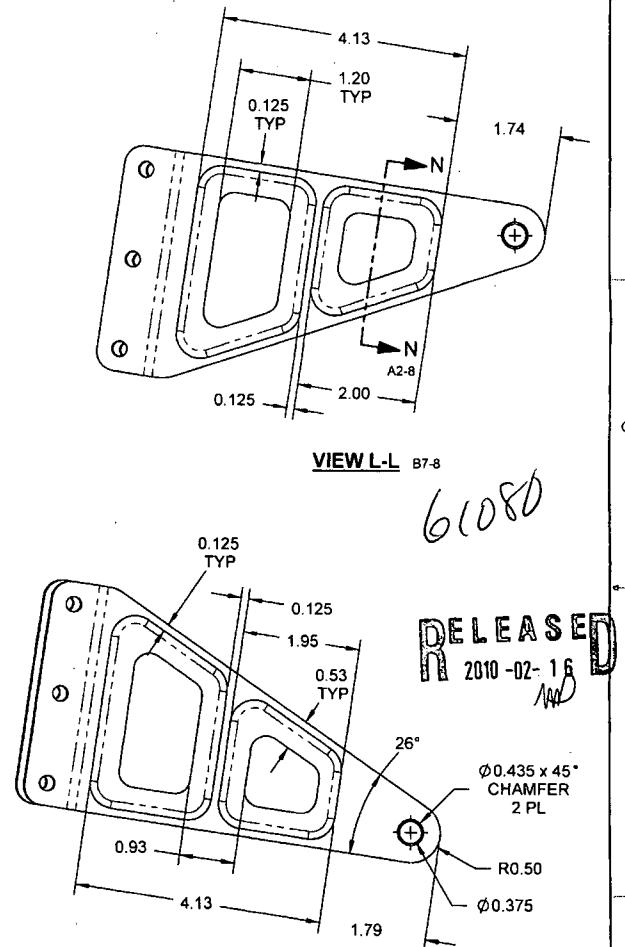


NOTES:

NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) BAR
PER AMS-QQ-A-225/8 (OR 4117/4128/4115/4116)
PER AMS-QQ-A-200/8 (OR AMS 4160)
REF DART SPEC, M6061T6B
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3
MASK Ø.257 HOLES AND INDICATED CHANNEL (ZN C7-8)
PRIOR TO POWDER COAT
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: .005 TO .010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4048-8" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.62 lbs

D4048-8 MOUNTING LUG



VIEW M-M C4-1

DESIGN	RF	DART AEROSPACE LTD		
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA		
CHECKED	<i>gj</i>	DRAWING NO.	REV. A	
MFG. APPR.	<i>gj</i>	D4048	SHEET 8 OF 9	
APPROVED	<i>hp</i>	TITLE	SCALE	
DE APPR.	<i>hp</i>	MOUNTING LUG ASSY NTS		
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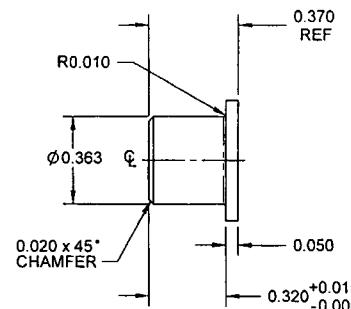
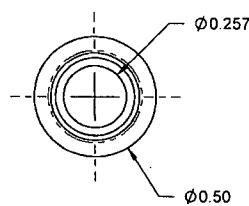
C

B

B

A

A



61080

D4048-9 BUSHING

NOTES:

- 1) MATERIAL: AISI 303 STAINLESS STEEL BAR
REF DART SPEC. M303B
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.01 lbs

DESIGN	RF	DART AEROSPACE LTD
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA
CHECKED	99	REV. A
MFG. APPR.	99	D4048
APPROVED	100	SHEET 9 OF 9
DE APPR.	100	TITLE
DATE	10.01.29	SCALE
		NTS

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